

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029218**Date Inspected:** 06-Mar-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

This QA Inspector observed at random intervals, ABF welder Matt Chochran #4320 performing Stud welding at hinge "A" expansion joint east in the 1G flat and 2G horizontal positions in accordance with ABF-WPS-D1.5-5062-STUD and 5062-STUD respectively. This QA Inspector verified that a 360° flash and weld was visible at the base of the studs as QC monitored the welding. This QA Inspector made subsequent observations to monitor quality and noted that the work at this location was in progress and appeared to be in general conformance with the contract documents.

This QA Inspector randomly observed ABF welder Mike Jimenez #4671 performing the in process Shielded Metal Arc Welding (SMAW) in the 1G flat position on the OBG Alignment Lug Hole (ALH) #2 on the west bound OBG. The welder was observed pre-heating the joint prior to welding with the QC Inspector monitoring the welding and the parameters in accordance with ABF-WPS-D1.5-1050B-Revision 1. The Amperage was recorded as 134 and the work was noted as being in progress and appeared to be in general conformance with the contract documents.

ABF welder Wai Kit Lai #2953 was observed performing the SMAW process in the 1G flat position on the Skyway East lifting lug hole (SLLH) #4. The welder was observed utilizing WPS ABF-D1.5-1030-Revision 1 for SMAW. The welder was observed preheating the welds prior to welding. Other welding parameters as inspected by the QC Inspector were recorded as 136 amperes and appeared to be in compliance with the WPS noted above.

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Upon completion of #4, the welder was observed beginning work on #6 on the interior of the skyway. The welder was observed preheating the welds prior to back gouging the root side of the weld. The QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was in progress and appeared to be in general conformance with the contract documents. CCO184 and RFI-003132R00 were referenced during the observations.

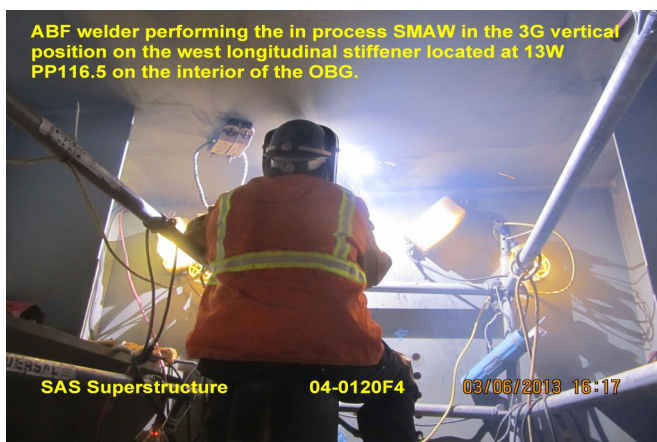
This QA Inspector made random observations of ABF welder Mike Jimenez #4671 utilizing the SMAW process in the 1G flat position on the diverter bars located at 13W PP100 to PP124 on the exterior of the OBG. The welder was observed pre-heating the deck prior to welding with the QC Inspector monitoring the welding and the parameters in accordance with ABF-WPS-D1.5-F1200A. The Amperage was recorded as 136 and the work was noted as being in progress and appeared to be in general conformance with the contract documents.

This QA Inspector made random observations of ABF welder Chris Bruce #8901 performing the SMAW process in the 3G vertical position utilizing E9018 electrodes on the Longitudinal Stiffeners located at 13W PP116.5-W2-LSW. The welder was observed utilizing WPS ABF-D1.5-1012-3 for SMAW. The welder was observed preheating the welds prior to welding. Other welding parameters as inspected by the QC Inspector were recorded as 138 amperes and appeared to be in compliance with the WPS noted above. This QA Inspector made subsequent observations throughout the remainder of the shift to monitor quality and noted that the work at this location appeared to be in general conformance with the contract specifications.

This QA observed QC Inspector Salvador Merino and William Sherwood performing welding parameter checks such as voltage, amps, electrodes and preheats throughout the day. Non-Destructive Testing methods utilized by the QC Inspectors were Visual Testing (VT), Magnetic Particle Testing (MPT) and Ultrasonic Testing Shear Wave (UTSW). QC Inspectors were observed performing inspection per applicable code and or contract criteria. Unless otherwise noted, all work observed on this date appeared to generally comply with the contract documents.

Summary of Conversations:

Conversations were relevant to work performed.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas 916-764-6027 , who represents the Office of Structural Materials for your project.

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Inspected By:	Frey,Doug	Quality Assurance Inspector
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Reviewed By:	Reyes,Danny	QA Reviewer
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